

Date: Friday, 9/1/2006 12:10:07 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 STEP ASSY LH *UNDER REVIEW**
 Job Number : 28393
 Estimate Number : 12438
 P.O. Number : N/A Part Number : D058677011
 This Issue : 9/1/2006 S.O. No. : N/A Drawing Number : D2943 UNDER REVIEW 06.09.01
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : UNDER R
 Previous Run : 28049 Material : N/A
 Written By : Due Date : 9/20/2006 Qty: 3 Um: Each
 Checked & Approved By : 06.09.01
 Comment : Est Rev: B 04.11 Combined with D2943-041 EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
2.0	D2622120C	Extrusion
3.0	D2734	206 Step Endplate
4.0	D2725	206 Step Lug
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1



Comment: Photocopy bluefile & type labels per PPPD058-677-011

CHG 001

06-09-06 KS.



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Extrusion D2622-120C

Batch: 327077

P.E. 06-09-06



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

D2734 206 Step Endplate

Batch: 327281

P.E. 06-09-06



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

D2725 206 Step Lug

Batch: 327283

P.E. 06-09-06



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

P.E. 06-09-06

P.E. 06-09-12

P.E. 06-09-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:10:07 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 28393

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch: m100660

4-Grind end cap welds flush as per dwg D2943

LE 06-09-12

3

6.0

QC5/9

WELD INSPECTION



LE 06-09-13 (3)



Comment: WELD INSPECTION

MA 06/09/20 (3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 06-09-20 (3)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 21 (3)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: m15689

LE 06-09-21

3

2-Grind end cap welds flush as per dwg D2943

FF 06-09-21

3

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

MA 06/09/22 (3)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

A.M 06-09-23 (3)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M 06-09-24 (3)

Y.L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:10:07 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 28393

Part Number: D058677011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M101667

aim

06-09-25

(B)

14.0	QC3/5	INSPECT WORK/WING WALK
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Comment: INSPECT WORK/WING WALK

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0	D27311	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: 15282 IM4

✓

20613

17.0	D27313	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

20614

✓

18.0	D27315	Mounting Lug
------	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: 22591

✓

19.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: B22592

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DF Date: 06/09/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 28393

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: M100743

21.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

M101390

22.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut

Batch: M19099

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location:

PPP Rev: B

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

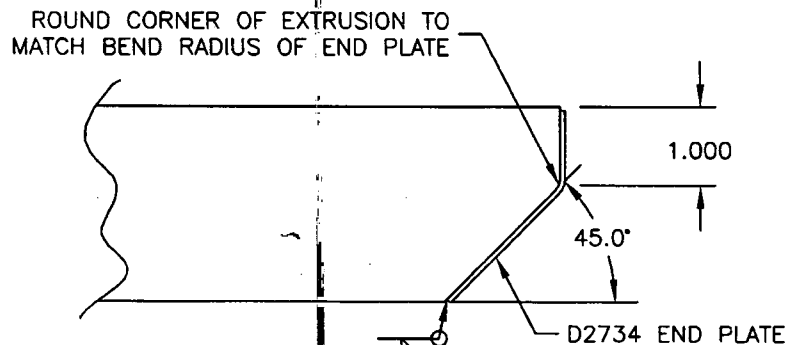
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

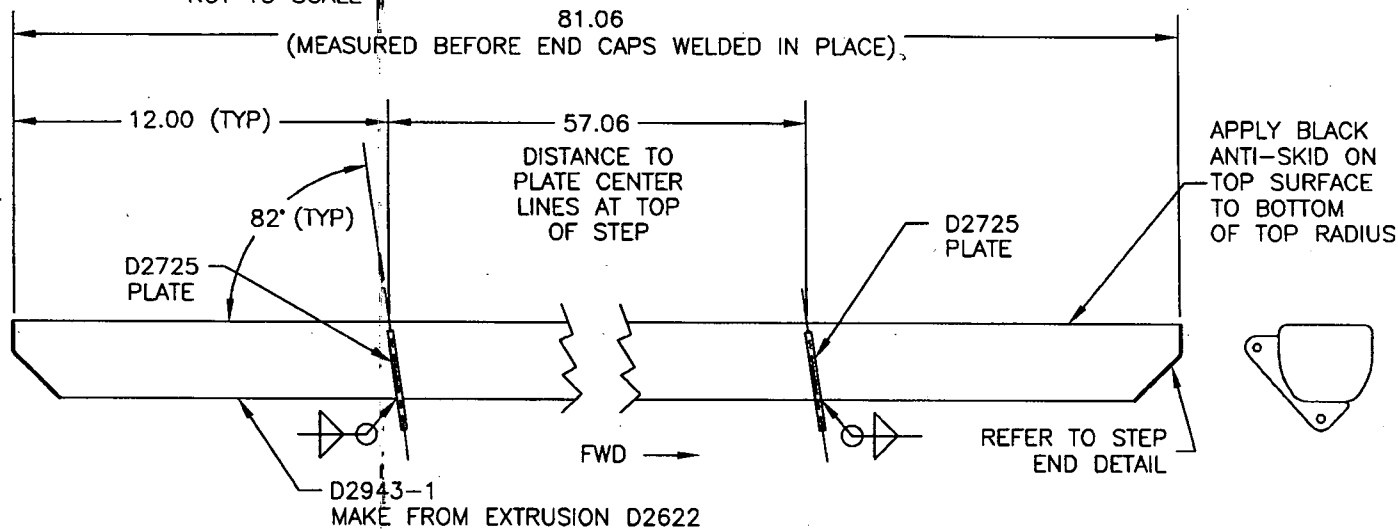
NOTE: Date & initial all entries

DART



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

TYPICAL STEP END DETAIL
NOT TO SCALE



D2943-041 LH STEP ASSEMBLY (SHOWN)
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*cut per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

05-11-28-18

UNDER REVIEW

~~13~~
06-03-29
06-03-01

~~UNDER REVIEW~~
06-03-29
RE-DELETION
JANUARY 10 0206-633

DESIGN	RF	DRAWN BY	PAJ	DART AEROSPACE USA, INC.		REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2943	SHEET 1 OF 1
DATE	05.11.14	TITLE		OH-58 STEP ASSEMBLY		SCALE
						NTS
A		99.11.19	NEW ISSUE			
B		05.11.14	UPDATE FINISHING NOTE			

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